

Work Order ID 161476

Wednesday, May 17, 2017 7:42:14 AM

161476

Page 1

Item ID: D2731-3 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Split - 1 - Stop *NS2*
 Item Name: Mounting Lug
 Start Date: 5/16/2017 Start Qty: 24.00 *24*
 Required Date: 5/23/2017 Req'd Qty: 24.00 *24*
 Reference: SCHEDULED 68-8
 Cust Item ID:
 Customer:

Approvals: Process Plan: MAY 17 2017 Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2731	Rev C

110	Outsource process - Machining	0.00							
110	HAAS CNC VERTICAL MACHINING #1								
Outsource5	Memo	4,320.00							
Outsource process - Machining	Issue P/O to Metec : 36351 Machine as per dwg C of C is required								

120	Receive & Inspect for Damage & Mat'l Certs	0.00							
120									
Packaging	Memo	0.48							
Packaging	ENSURE C OF C IS ATTACH.								

130	QC6- All purchased or subcontracted products	0.00							
130									
QC	Memo	0.00							
Quality Control									

JUN 27 2017

1000 3 500

Work Order ID 161476

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Wednesday, May 17, 2017 7:42:15 AM

Item ID: D2731-3 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Mounting Lug
 Start Date: 5/16/2017 Start Qty: 24.00 *24* Cust Item ID:
 Required Date: 5/23/2017 Req'd Qty: 24.00 *24* Customer:
 Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140	HandFinish	0.37				(x24)			20170704 BEB.
	Hand Finishing								

145		0.00							
145	Spray Paint	0.00							
	Spray Painting								
	Issue PO			36936	x 24				
	Memo								
	PRIME B								
	SPRAY PAINT DELFEET BLUE								
	B								
	CLEAR DELFLEET B								
	QC14- Inspect Spray Paint								
	Memo								
	Quality Control								

147 Packaging Receive + Inspect

QC14- Inspect Spray Paint

QC

Quality Control

22x SP17-711

22

DAS 38 9-89

JUL 11 2017

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Wednesday, May 17, 2017 7:42:15 AM

Item ID: D2731-3 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Mounting Lug
 Start Date: 5/16/2017 Start Qty: 24.00 *24* Cust Item ID:
 Required Date: 5/23/2017 Req'd Qty: 24.00 *24* Customer:
 Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>5453Z</u>	0.00							
170									
Packaging	Memo	0.24							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	2.40							
Quality Control									

24

DAS
9-89
JUL 11 2017

17/7/13

U 17.07.12

Picklist Print

Wednesday, May 17, 2017 7:42:13 AM

Page 1

Work Order ID: 161476

161476

Parent Item: D2731-3

D2731-3

Parent Item Name: Mounting Lug

Start Date: 5/16/2017

Required Date: 5/23/2017

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP: D00.05.19Added inspect level 8, removed P/O for powder coatingEC
OUTSOURCE METEC DD VERF:JFS IPP REV:E 13.06.25

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423 *D2423* Lug Extrusion		Manufactured	No			110	f	332.9093	0.0683	1.725474		DAS 13 9-89	MAY 17 2017

**

Location

Loc Qty

Loc Code

Metec

332.9092737

64

115229

83.2745647

127892

185.634709

148835

D2731-3P

Purchased

No

100

Each

0.0000

1

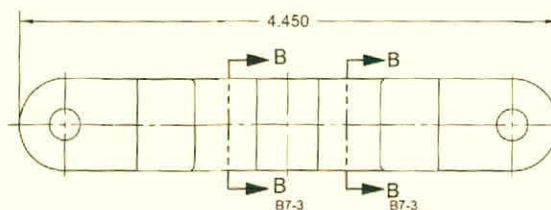
24

D2731-3P

Lug

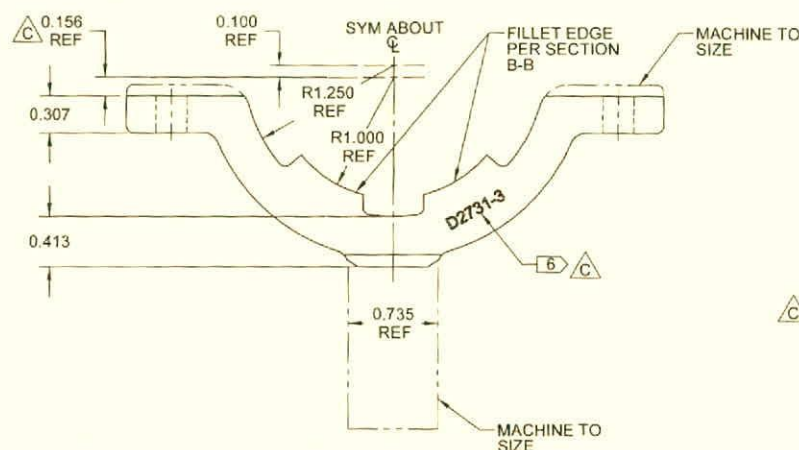
**

W
24/x 8/17-6-26



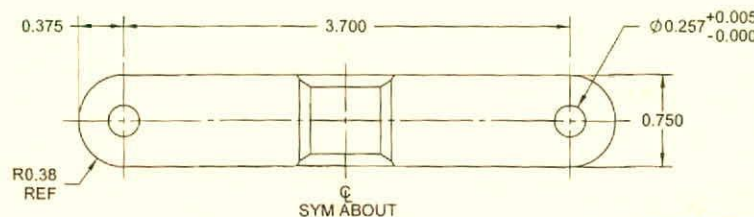
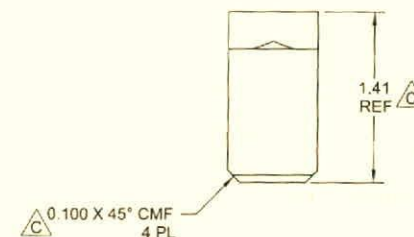
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 161476 M.C.S
170516



SECTION B-B D4-3
SCALE 2X

R0.06 MIN-R0.10 MAX
2 PL



D2731-3 MOUNTING LUG

DEO ATTACHED
RELEASED
09/05/25

DESIGN	KE	DART AEROSPACE USA, INC.	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2731	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.19	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

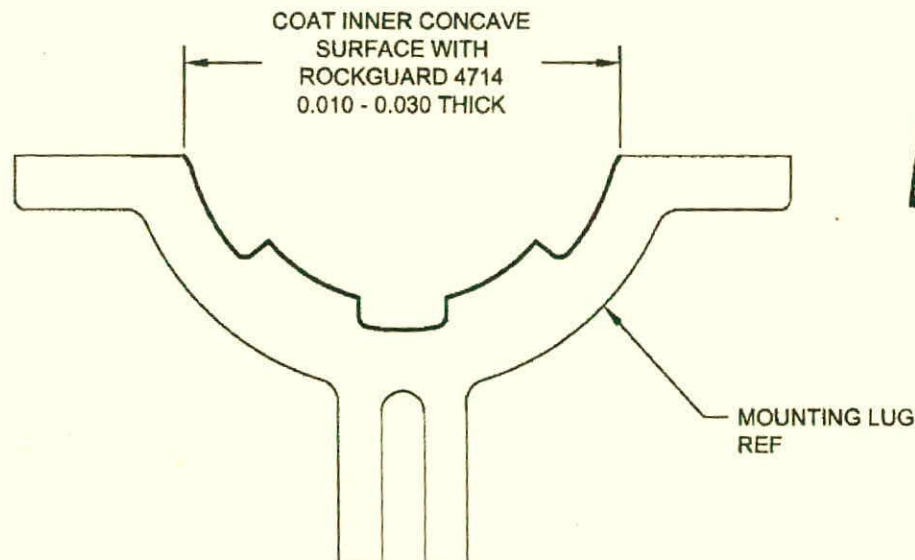
DRAWING NO. D2731	TITLE MOUNTING LUG	REV. C	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D2731-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>q</i>	CHECKED <i>sc</i>	MFG. APPR. <i>MA</i>	APPROVED <i>MA</i>		DE APPR. <i>MA</i>		
DATE 11.05.02	DATE 11.05.09	DATE 11.05.09	DATE 11.05.09		DATE 11.05.09		

PURPOSE

ADD D2731-xRG OPTION

CHANGE

D2731-xRG MOUNTING LUGS ARE INDENTICAL TO D2731-x MOUNTING LUGS, HOWEVER AFTER FINISH, COAT INNER CONCAVE SURFACE WITH "PLUS ONE ROCKGUARD 4714" AS SHOWN BELOW.



D2731-1RG MOUNTING LUG (SHOWN)
D2731-3RG/-5RG/-7RG MOUNTING LUGS (SIMILAR)

RELEASED
2011-05-24
MD

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO36351

Purchase Order Date 5/17/2017

PO Print Date 5/17/2017

Page Number 1 of 3

Order From:

METEC META! TECHNOLOGY INC.
20 TULLY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

VC-MET003

Ship To: DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

MAY 17 2017

Contact Name

Vendor Phone 613 678 3957

Ship To Contact

Ship To Phone

Ship Via: Dart Truck

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 10

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2731 1P AS PER DWG D2731 REV. C B161476 ALODINE AND PAINT NOT REQUIRED. MACHINE LUGS ONLY	Lug	5/31/2017 Yes 5/31/2017		24.00 Each	\$15.00	\$360.00
Line Total:							\$360.00
2	D3394 3PL AS PER DWG D3394 REV. B B161479 ALODINE AND PAINT NOT REQUIRED. MACHINE LUGS ONLY	Lug	5/31/2017 Yes 5/31/2017		20.00 Each	\$16.10	\$322.00
Line Total:							\$322.00

DAS
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9-89

SP17-6-26

SP17-6-7

Note:

5/17/2017



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: **21748**
Date: Jun 20, 2017
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 36351	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date: Jun 20, 2017

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2731-3 Mounting Lug, Rev. C not painted ETA June 9, 2017	Each	24	24	
D3394-3 Lug, Rev. B not painted ETA June 9, 2017	Each	20		
D2731-7 Lug, Rev. C Alodined and painted as per QSI 005 stock	Each	24		
D3910-3 Crosstube Lug, Rev. E Alodined and painted as per QSI 005 stock	Each	30		
D4091-1 Lug, Rev.A Alodined and painted as per QSI 005 ETA June 13, 2017	Each	60		
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by <u>SP 17-6-26</u>		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

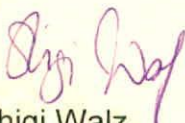
same

Quantity	Part Number	Part Name	Paint Batch #	P.O. Number
24	D2731-3	Mounting Lug	Unpainted	36351

MATERIAL: supplied by DART B115529

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, June 20, 2017



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO36936**

Purchase Order Date 7/5/2017

PO Print Date 7/7/2017

Page Number 1 of 5

Order From :

VC-ATE001

Ship To : DART AEROSPACE LTD

ATELIER DEBOSSSELAGE
358 PRINCIPALE
CALUMET, QC J0V 1B0
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Revised

Contact Name

Vendor Phone

819 242 5633

Ship To Contact

Ship To Phone

Ship Via:

Dart Truck

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	161585	D2932-2BL Saddle RH Out, 206	7/10/2017 Yes 7/10/2017		12.00 Each	\$25.00	\$300.00
Line Total:							\$300.00
2	161578	D2680-041 Nut Plate	7/10/2017 Yes 7/10/2017		39.00 Each	\$4.00	\$156.00
Line Total:							\$156.00
3	161476 ✓	D2731-3 Mounting Lug ✓	7/10/2017 Yes 7/10/2017		24.00 Each	\$18.00	\$432.00

*07/07/17
KOB*

*Rec'd 22x
SP17-7-11*

Note:

7/7/2017

